

Blue

Monday, 17/11/2008 10:37:13 AM

User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|--------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 206L FWD X-TUBE |
| Job Number : | 43469 | Part Number : | D206667103BL |
| Estimate Number : | 10553 | Drawing Number : | D206-667-143 REV B |
| P.O. Number : | | Project Number : | N/A |
| This Issue : | 17/11/2008 | Drawing Revision : | |
| Prsht Rev. : | NC | Material : | |
| First Issue : | 1/1 | Due Date : | 15/12/2008 |
| Previous Run : | 42586 | Qty: | 1 Um: Each |
| Written By : | | | |
| Checked & Approved By : | JUD 08.11.17 | | |
| Comment : | Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJJ/LM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by: | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D206667103TRN

Crosstube Turning Detail



Comment: Qty: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 15-4304

MB 08-11-25

4.0

BENDING

BENDING MACHINE SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1


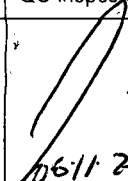

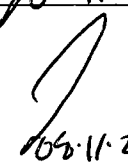
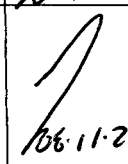


Comment: LANDING GEAR RESOURCE 1

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

MB 08-12-02

| W/O# | | WORK ORDER CHANGES | | | | | | |
|----------|------|--|--|---|----------|-----|---|---|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng Prod Mgr | Approval QC Inspector |
| 06-11-26 | 4.0 | QC 15 required after bending perm. change | | | | |  |  |
| 06-11-26 | 4.1 | QC 15 | |  | 06-11-26 | 1 |  |  |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:37:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 43469

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff (Do not engrave on outside of tube)

MB
08-12-02

MB
08-12-02

MB
08-12-02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB
08-12-02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MB
08-12-02

8.0

QC5

checked h/w 8/12/02

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MB
08-12-02

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

P10: 7782 C208/12/08

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P-8/2/05 (1)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:37:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 43469

Part Number: D206667103BL

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----|-------------------|
| 11.0 | QC6 | DIMENSIONAL CHECK |
|------|-----|-------------------|



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

808/12/08 @

| | | |
|------|----------------|----------------|
| 12.0 | SPRAY PAINTING | SPRAY PAINTING |
|------|----------------|----------------|



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY

2-

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

RT 08-12-11

| | | |
|------|------|---------------------|
| 13.0 | QC14 | INSPECT SPRAY PAINT |
|------|------|---------------------|



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ml 08 12 11 (1)

| | | |
|------|-------------|----------------------------|
| 14.0 | D3595075395 | RUBBER CUSHION .75" x 3.95 |
|------|-------------|----------------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION .75" x 3.95

B 42998

ml 08 12 11

| | | |
|------|----------|--------------------|
| 15.0 | D2873043 | Nut Plate Assembly |
|------|----------|--------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

41988

RT 08-12-10

| | | |
|------|----------|--------------------|
| 16.0 | D2873045 | Nut Plate Assembly |
|------|----------|--------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

41987

RT 08-12-10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: 206L FWD X-TUBE

Job Number: 43469

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support 43383

ml 08 12 11

18.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

109297

RT 08-12-10

19.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp 107501

ml 08 12 11

20.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Magnabond B# 109900 exp: 02/2010

1-Install abrasion strips as per QSI-035 using DT8579. Note: (2) Aft holes should be facing up.

ml 08 12 11 ①

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

ml 08 12 12 ①

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

RT 08-12-10

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 12 12 ①

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L FWD X-TUBE

Job Number: 43469

Part Number: D206667103BL

Job Number:



Seq. #: Machine Or Operation: Description :

23.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

50

24.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

50

25.0 AN57A Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M107378

M109061

50

26.0 AN530A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M105144

M109061

50

27.0 AN960JD516 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109282

50

28.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

Rec

Signature

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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Date: Monday, 17/11/2008 10:37:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 43469

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

31.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

①
Done 12/12

Job Completion



in 08/12/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

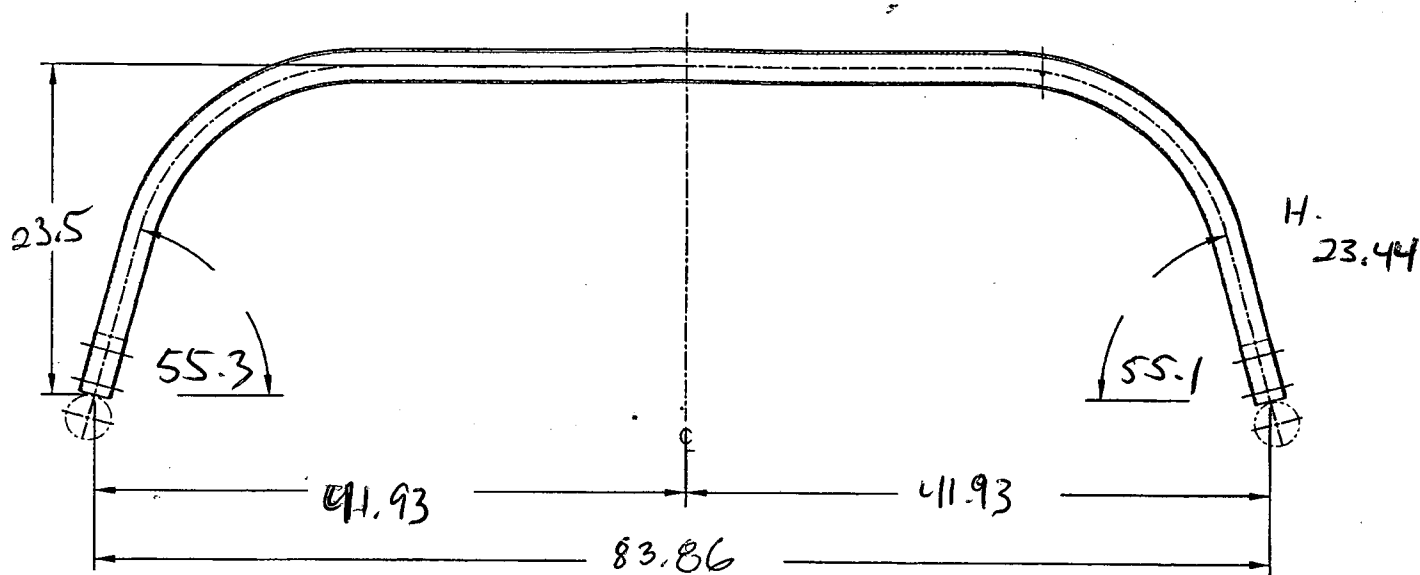
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | |
|--|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 43409 |
| Description: Crosstube High Fwd (206L) | | Part Number: D206-667-103 |
| Inspection Dwg: D206-667-143 Rev: B | | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
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| |
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| | |
|-----------------|----------|
| QC15 Inspection | |
| Date | 06.11.26 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |

| Item | Qty -143 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43469

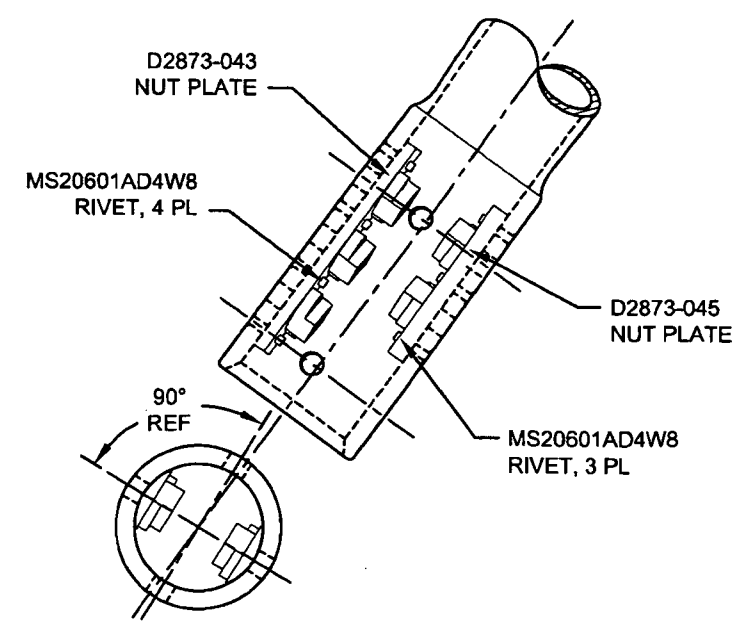
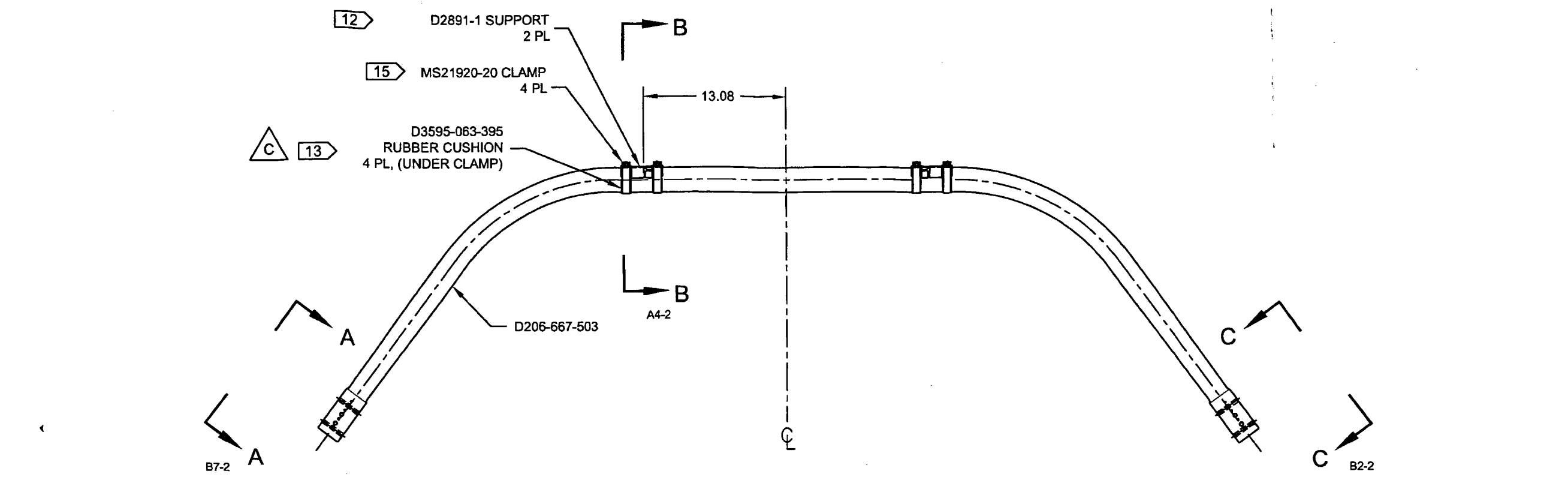
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08/11/06

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|------------|---|--|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. | REV. C |
| CHECKED | RF | D206-667-143 | SHEET 1 OF 4 |
| MFG. APPR. | RF | TITLE | SCALE |
| APPROVED | RF | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
| DE APPR. | RF | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.11.06 | | |

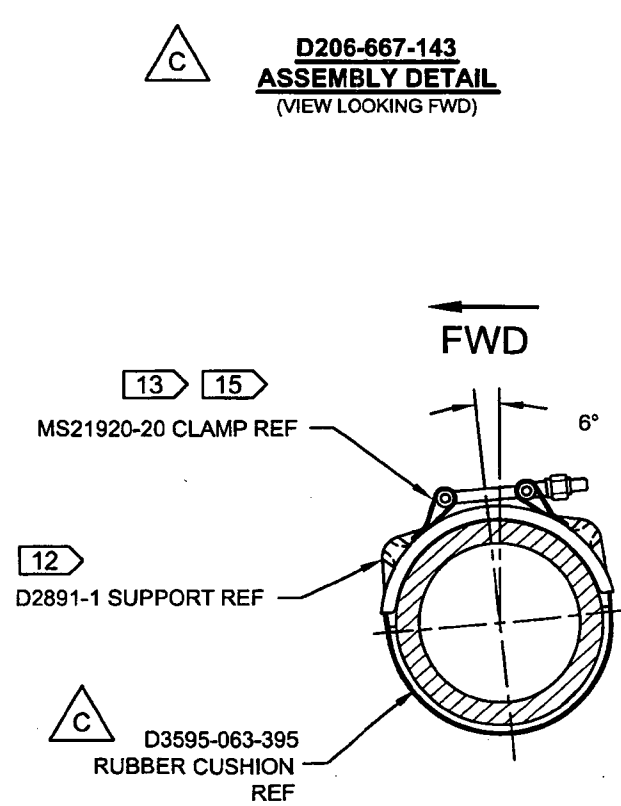
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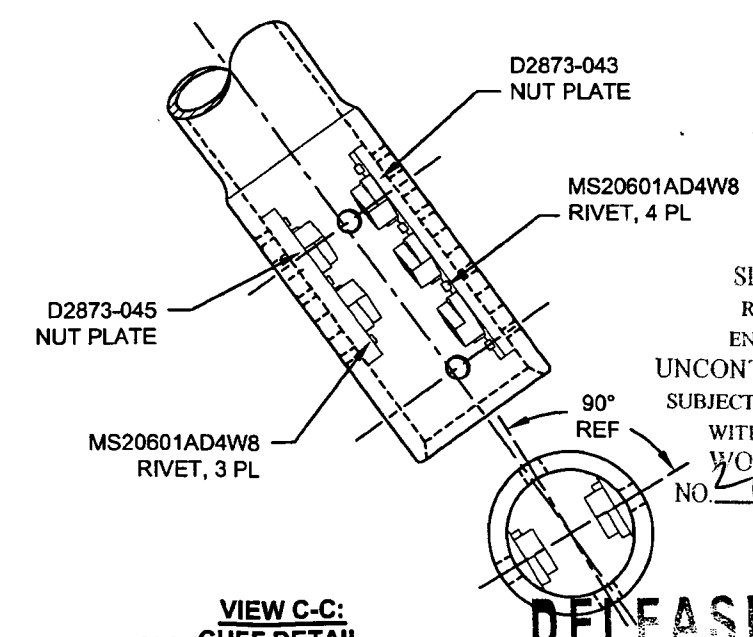
D
C
B
A



VIEW A-A:
CUFF DETAIL
SCALE 4X







D206-667-143
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

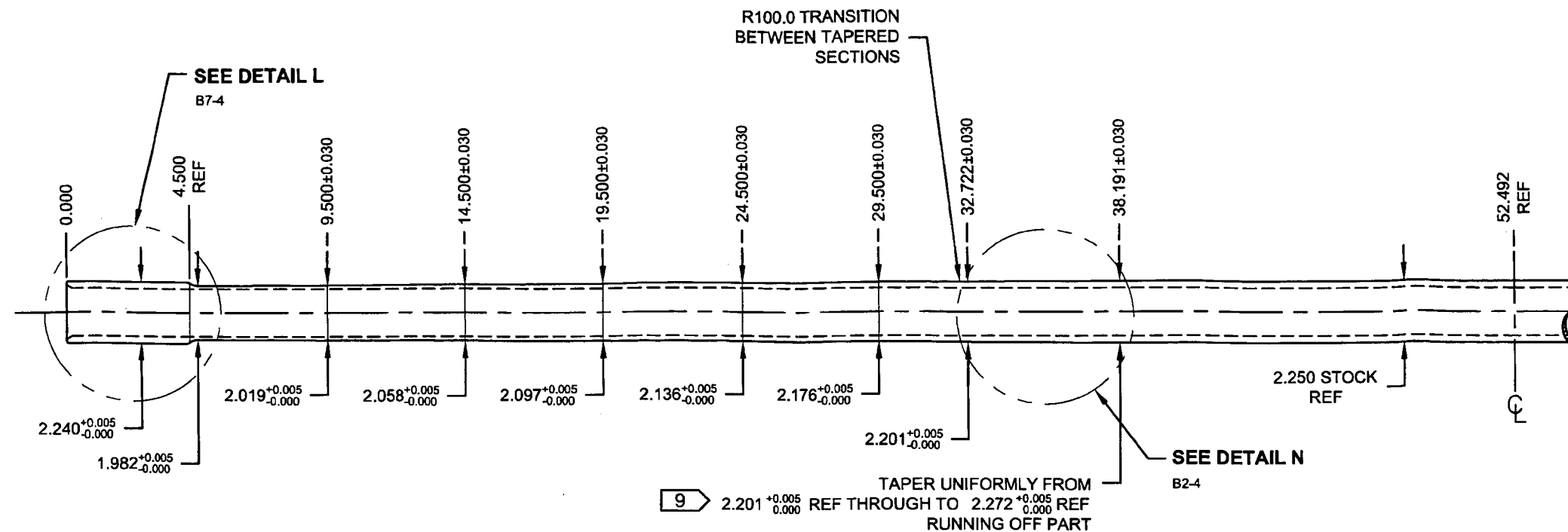


VIEW C-C:
CUFF DETAIL
SCALE 4X

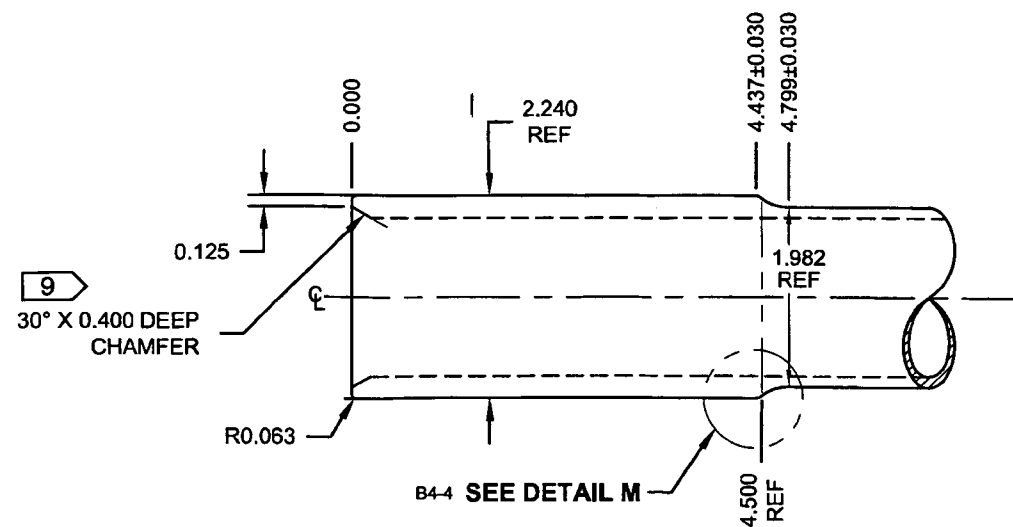
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 413409

RELEASED
08/11/12 MP

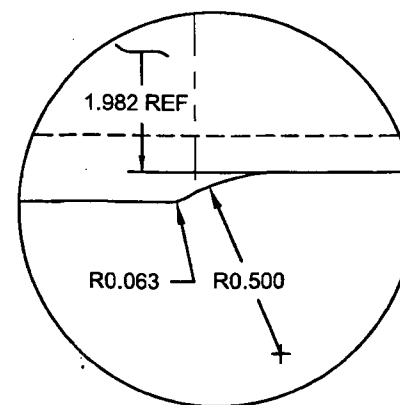
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| DESIGN | 90 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. C |
| MFG. APPR. |  | D206-667-143 | SHEET 2 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
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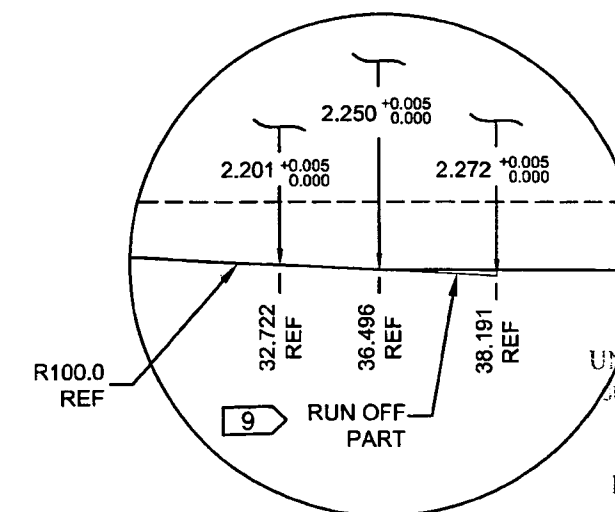
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43469

RELEASED

| | | | |
|--|----------|--|--------------|
| DESIGN | 92 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | UP | DRAWING NO. | REV. C |
| MFG. APPR. | EF | D206-667-143 | SHEET 4 OF 4 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | MP | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
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LIQUID PENETRANT TEST REPORT

P- 09133

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Dec 5th 2008 TIME AM ☐ PM ☐
ATTENTION Linda Lacelle ACUREN JOB NO. 188-08-1626
ADDRESS 1270 Aberdeen POWO No. _____
Hawkesbury, Ont. WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417 REV./DATE _____
PROJECT 206L FWD X-TUBE
ITEM(S) EXAMINED Job #'s 43469, 43470, 43471, 43472, 43491, 43492

| | | | |
|--|---|---|---------------------------------------|
| JOB DESCRIPTION | | PROCEDURE No. <u>LT-000</u> REV./DATE | TECHNIQUE No. <u>LT-000</u> REV./DATE |
| PART No. <u>D206667103 BL</u> | | MATERIAL <u>ALODINE ALUM.</u> THICKNESS | |
| SCOPE <u>WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON</u> <u>100% EXTERNAL SURFACE</u> | | | |
| TEST DETAILS | | | |
| METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE | <input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED | | |
| FAMILY BRAND <u>Magnaflux</u> | BLACK LIGHT S/N <u>8171</u> <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc | | |
| PENETRANT MINIMUM DWELL TIME <u>30</u> MIN. | LIGHTING EQUIP. <input checked="" type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE | | |
| PENETRANT REMOVER <u>H₂O</u> MINIMUM DRY TIME <u>>10</u> MIN. | OTHER <u>CAL FEB 09</u> | | |
| DEVELOPER <u>SK D52</u> MINIMUM DWELL TIME <u>10</u> MIN. | LIGHT METER S/N _____ CAL DUE DATE | | |
| DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY | | | |

| | | | |
|--|--|--|--|
| TEST SURFACE | | | |
| SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL | | | |
| SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F | | | |

| RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL) | | ACCEPT | REJECT |
|---|----------|-------------------------------------|--------|
| ITEM | COMMENTS | | |
| Job # <u>43469:</u> | | <input checked="" type="checkbox"/> | |
| <u>43470:</u> | | <input checked="" type="checkbox"/> | |
| <u>43471:</u> | | <input checked="" type="checkbox"/> | |
| <u>43472:</u> | | <input checked="" type="checkbox"/> | |
| <u>43491:</u> | | <input checked="" type="checkbox"/> | |
| <u>43492:</u> | | <input checked="" type="checkbox"/> | |
| <u>06/12/06</u> | | | |

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
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| | | | |
|--|---|---------------------|--|
| SIGNATURES | | DTR # | |
| CLIENT REPRESENTATIVE <u>Melanie Fautoux</u> | <u>M. Fautoux</u> SIGNATURE | REPORT REVIEWED BY: | |
| TECHNICIAN (SIGNATURE): <u>Frederick Chagnon</u> | <u>Frederick Chagnon</u> 1 ST TECHNICIAN | NAME INITIALS | |
| NAME (PRINT): <u>Frederick Chagnon</u> | CGSB LEVEL <u>II</u> SNT LEVEL <u>II</u> CGSB REG. NO. <u>10560</u> | | |
| | 2 ND TECHNICIAN | | |

WHITE - CLIENT COPY

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PINK - TECHNICIAN COPY

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Date: Wednesday, 19/11/2008 8:59:27 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43469
Estimate Number : 10553
P.O. Number :
This Issue : 19/11/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : 17/11/2008 **Type** : CROSSTUBES
Previous Run : 42586
Written By :
Checked & Approved By :
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM
Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
verified by:
Drawing Name : 206L FWD X-TUBE
Part Number : D206667103BL
Drawing Number : D206-667-143 REV B
Project Number : N/A
Drawing Revision :
Material :
Due Date : 15/12/2008 **Qty:** 1 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



JUD 08.12.05

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

2.0 PACKAGING 1 PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

3.0 D206667103TRN Crosstube Turning Detail

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch _____

Job Completion

